

# Work Order ID 52165

September 17, 2009 10:12:35 AM



# PRELIMINARY ISSUE

Page 1

Item ID: D212-725-1-245

Accept



Setup Start



Revision ID: G-PRELIM

Stop



Item Name: Cam

Start Date: 17/09/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 18/09/2009 Req'd Qty: 1.00

Customer:



Reference:

*Handwritten signature and date: 09.09.17*

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D212-725-1	G-PRELIM								

100

0.00



Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks 3.250" long

*Handwritten signature and date: 09/09/08*

1

1

110

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per folio FA844 and DWG

Folio rev: AA

Dwg Rev: A

Deburr as per Dwg

*Handwritten signature and date: 09/09/08*

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D212-725-1-245 PAR #: \_\_\_\_\_ Fault Category: Machining <sup>used for R & P</sup> NCR: Yes (No) DQA: / Date: 09-09-21  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>52165</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/09/18	110	Mirror of part was machine  Programme Error	<u>/</u> BSIMUR	Scrap and replace in <u>108961</u>	<u>muf</u> 09/09/21	<u>/</u> 09-09-21	<u>/</u> BSIMUR	<u>/</u> 09-09-21
09/09/18	110	Part came out of second operation too small  Programme error	<u>/</u> BSIMUR	Scrap and replace in <u>108961</u>	<u>muf</u> 09/09/21	<u>/</u> 09-09-21	<u>/</u> BSIMUR	<u>/</u> 09-09-21

NOTE: Date & initial all entries

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC Quality Control	Memo	0.00							
				mmf 09/09/18					
130 	Mill Conv	0.00							
Conventional Milling Machine	Memo	0.00							
	Drill & tap as per Dwg			mmf 09/09/18					
140 	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC Quality Control	Memo	0.00							
				mmf 09/09/18					

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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

*Jan 09.09.18*

*(1)*

160

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

*N/A Jan*

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

*N/A Jan*

POSITIVE RECALL

EFFECTIVE

FILED

AUTH

DATE

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Cust Item ID:

Required Date: 18/09/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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180



Small Fab

Memo

Small Fab

Insert Helicoil as per Dwg

0.00

0.00

*N/A J. J. 09-09-18*

190



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

*N/A J. J. 09-09-18*

200



Packaging

Packaging

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

Memo

0.00

0.00

*Ship To Roberto  
IN CAL. J. J.*

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

NO C of C OR QC 21 FOR THIS PART

changed  
to RD 0315 sep mr  
09-09-18

# Picklist Print

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Page 1

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Parent Item: D212-725-1-245RevG-PRELIM



Parent Item Name: Cam

Start Date: 17/09/2009

Required Date: 18/09/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B0.625X02.50 0		Purchased	No			100	f	8.8000	0.3158			



6061-T6 Bar .625 x 2.50

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

8.8

108961

8.8

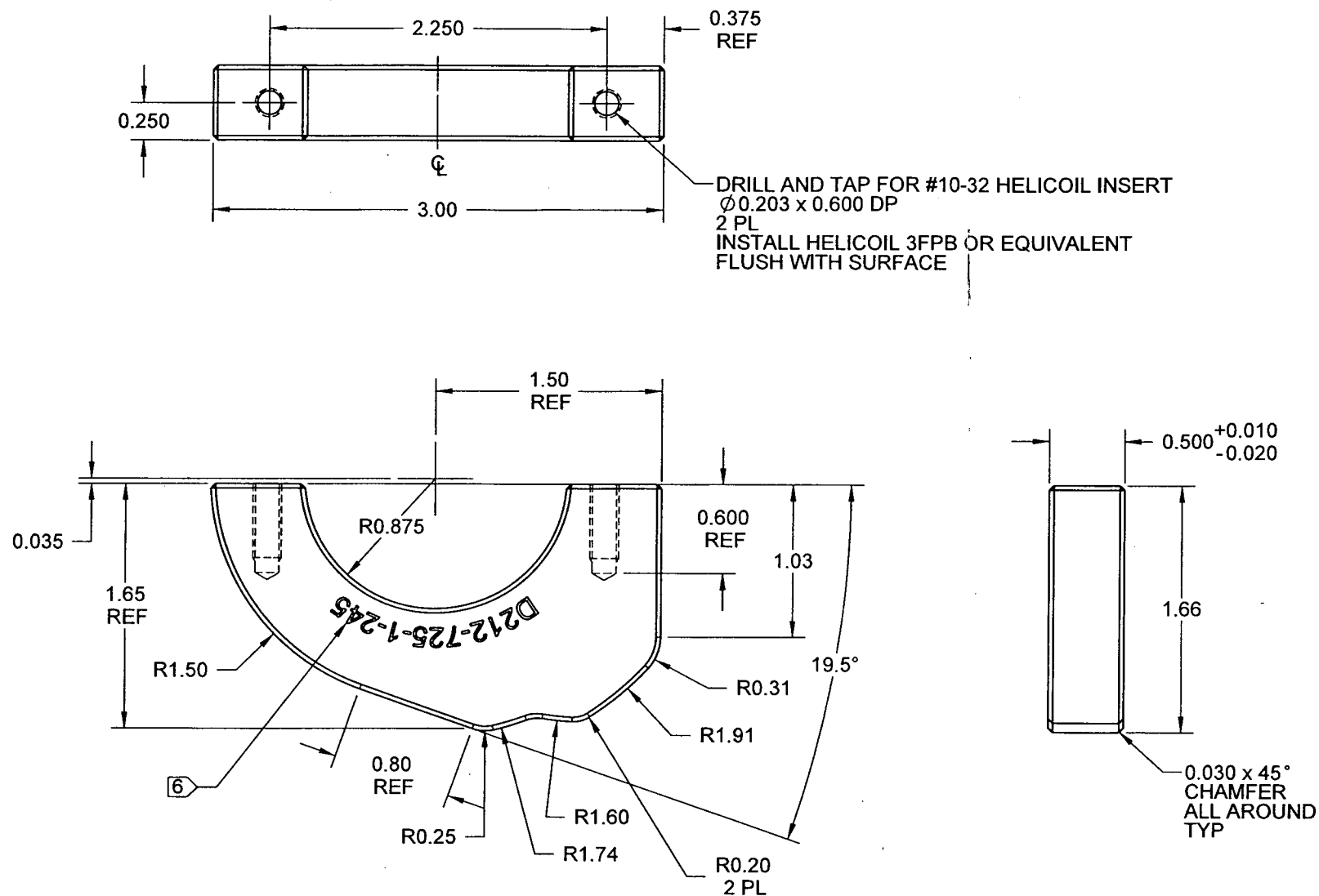
W  
09/09/08

0.316





ITEM No.	QTY	PART NUMBER	DESCRIPTION
1	1	D212-725-1-245	CAM
2	2	3FPB	#10-32 HELICOIL INSERT



**D212-725-1-245 CAM**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
REF. DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE WITH DART P/N IN THIS AREA AS SHOWN TO MAX DEPTH  
OF 0.015 IN 0.135 HIGH LETTERS WITH A MIN RADIUS TOOL OF 0.015
- 7) WEIGHT: 0.14 lbs

**PRELIMINARY**

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D212-725-1</b>	REV. G
MFG. APPR.		SHEET 85 OF 86	
APPROVED		TITLE <b>212S DETAIL PARTS</b>	SCALE NTS
DE APPR.		COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	<b>09.09.03</b>		